DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-018169
Date Inspected: 17-Nov-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC)

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: N/A

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**CWI Present:**	☐ Yes	☑ No	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
				Approved WPS:	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 11CE to Segment 11DE (Transverse Splice T-Ribs)

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector Mr. Murugan Manikandan on the Transverse Splice T-Ribs to T-Ribs for the Segment 11CE to Segment 11CE between Panel Point (PP) 103 to PP 104 at the following locations:

Work Point E1 towards Work Point E3 (Side Panel Bike Path Side) total 19 T-Ribs.

Work Point E3 towards Work Point E4 (Bottom Panel) total 18 T-Ribs.

Work Point E4 towards Work Point E6 (Side Panel Cross Beam Side) total 19 T-Ribs.

The QA Inspector measured the Vertical Offset using 1(One) Meter Straight Edge and measured the Horizontal Offset on the web using a Bridge Cam gauge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 11CE to Segment 11DE (Skin Flatness)

This QA Inspector performed Joint Inspection along with Caltrans QA Inspector Mr. Murugan Manikandan to check the skin flatness between Segment 11CE to Segment 11DE between Panel Points (PP) 103 and PP 104 at the following locations after heat straightening the out of tolerance locations:

The skin flatness was measured on South side (Bike Path Side at B4 locations) at 100mm from the weld connecting Bottom Panel to Side Panel using 5000mm string line to verify overall flatness. The straight edges of 600mm and 630 mm of length were also used to measure the localized flatness.

The skin flatness was measured on North side (Cross Beam side at T1 location) and South side (Bike Path Side at T2 location) at 100mm from the weld connecting Deck Panel to Edge Panel using 5000mm string line to verify overall flatness. The straight edges of 600mm and 630 mm length were also used to measure the localized flatness.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Bike Path at Bay # 8

This QA Inspector performed Dimension Control Inspection on the Bike Paths bottom panel for flatness check across the longitudinal butt weld. Flatness check was performed on following mentioned Bike Paths and Y locations for out of flatness was measured from piece mark BKPL6A towards piece mark BKPL6B, the reports were submitted to Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel. The flatness check was performed on the following mentioned Bike Paths:

BK004A-055 and
BK004A-054

The QA Inspector measured the flatness using 600mm long straight edge and observed flatness dimensions out of allowable tolerance.

Bike Path at Bay # 11

This QA Inspector performed Dimension Control Inspection on the Bike Paths bottom panel for flatness check across the longitudinal butt weld. Flatness check was performed on following mentioned Bike Paths and Y locations for out of flatness was measured from piece mark BKPL6A towards piece mark BKPL6B, the reports were submitted to Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel. The flatness check was performed on the following mentioned Bike Paths:

BK004A-018

BK004A-021 and
BK004A-017

The QA Inspector measured the flatness using 600mm long straight edge and observed flatness dimensions out of allowable tolerance.

Please reference the pictures attached for more comprehensive details.

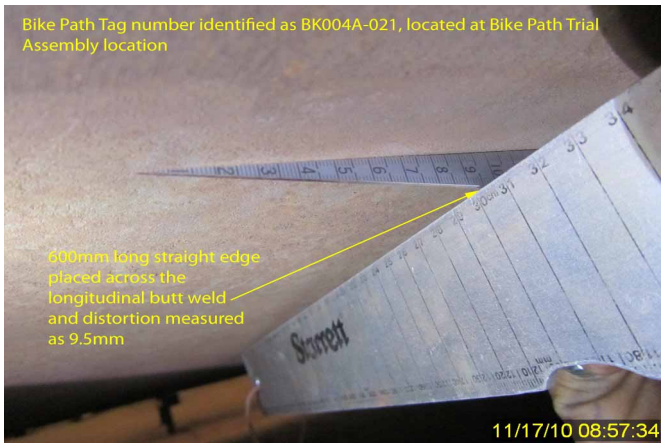
Bike Path at Bay # 19

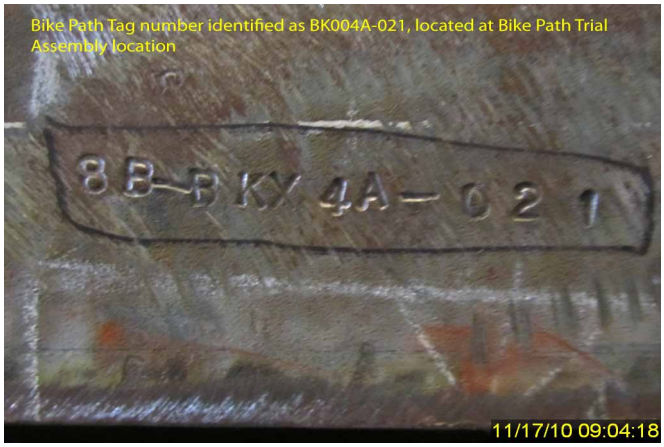
This QA Inspector performed Dimension Control Inspection on the Bike Paths bottom panel for flatness check across the longitudinal butt weld. Flatness check was performed on following mentioned Bike Paths and Y locations for out of flatness was measured from piece mark BKPL6A towards piece mark BKPL6B, the reports were submitted to Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel. The flatness check was performed on the following mentioned Bike Paths:

BK004A-008 and
BK004A-010

The QA Inspector measured the flatness using 600mm long straight edge and observed flatness dimensions out of allowable tolerance.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer